

Date: Friday, 25/01/2008 9:06:16 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: FUEL SCUPPER ASSEMBLY		
Job Number	: 36917A01			Part Number	: D32701		
Estimate Number	: 10151			Drawing Number	: D3270 REV B		
P.O. Number	:			Project Number	: N/A		
This Issue	: 25/01/2008	S.O. No.	:	Drawing Revision	: B		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: LARGE FAB ASSY	Due Date	: 29/02/2008	Qty:	30
Previous Run	: 36940A			Um:	Each		
Written By	:			Comment	:		
Checked & Approved By	:			Est Rev: A	New Issue	05-11-01 JLM	
				Est Rev:B	now water jet	08-01-24 DD	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S040	6061-T6 .040 Sheet
		 Comment: Qty.: 0.0393 sf(s)/Unit Total : 0.7854 sf(s) 6061-T6 .040" thick sheet (M6061T6S040) Batch: 105842 <i>(B) 8-1-28</i>
2.0	WATER JET	FLOW WATER JET
		 Comment: FLOW WATER JET 1-Cut as per Dwg D3270 Dwg Rev: <i>B</i> <i>(B) 8-1-28</i> <i>30</i> Prog Rev: <i>B</i>
		2-Deburr if necessary
3.0	QC8	SECOND CHECK
		 <i>(B) 8-1-28</i>
		Comment: SECOND CHECK
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		 <i>S 08/01/28 (30)</i>
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		 <i>80/01/28 30</i>
		Comment: SMALL & MEDIUM FAB RESOURCE 1
		1-Deburr if necessary <i>80/01/28 30</i> 2-Form D3270-1 and drill holes using D3270-1T1 as per Dwg D3270
		<i>FF 08-01-29</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 01/02/01
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



6810130 (730)

Comment: INSPECT WORK TO CURRENT STEP

7.0 QC21

FINAL INSPECTION/W/O RELEASE



(30)

Comment: FINAL INSPECTION/W/O RELEASE

730102101

Job Completion



cL0810131

-76.A

Racking ID+stack

8/1/31 SQ

(30X)

DART AEROSPACE LTD	Work Order:	36917A01
Description: Mounting Base	Part Number:	D3270-1
Inspection Dwg: D3270	Rev: AB	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>B</u>	Audited by:	<u>J</u>	Prototype Approval:	N/A
Date:	8-1-28	Date:	<u>8/1/28</u>	Date:	N/A

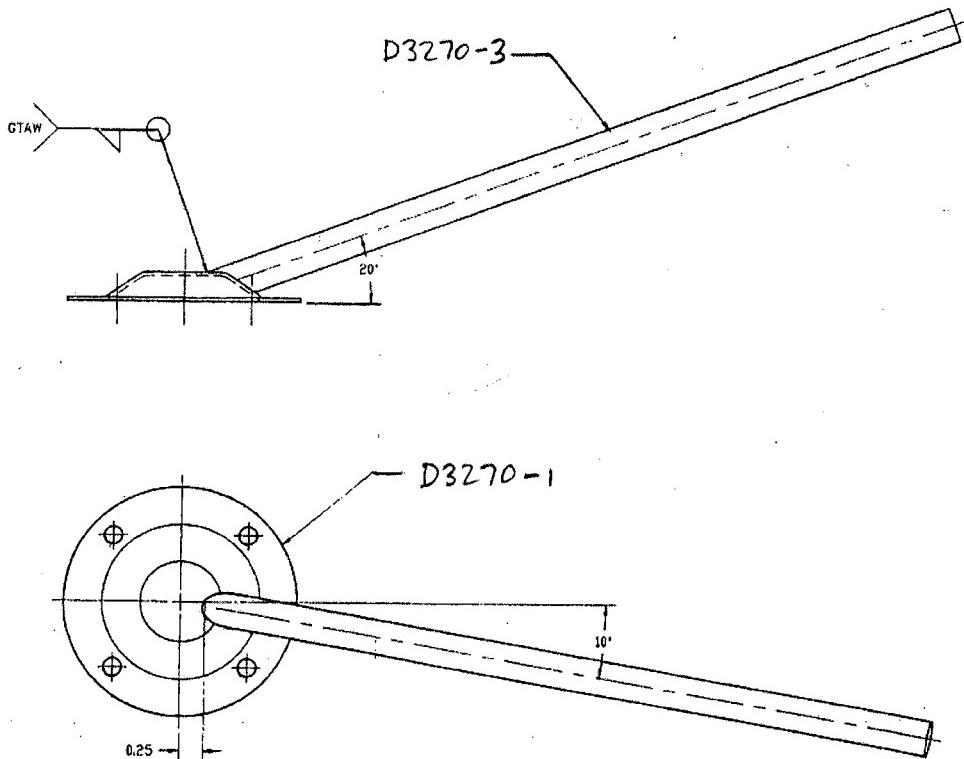
Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue (P/O D206-718-011)	KJ/RF	
B	04.09.28	Change diameter dimensions	KJ/JLM	
C	06.03.15	Dimension and tolerance revised	KJ/JLM	<i>[Signature]</i>

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D3270	SHEET 1 OF 2
DATE	05.07.14	TITLE	SCALE
		FUEL SCUPPER DRAIN ASSEMBLY	NTS
A	04.02.20	NEW ISSUE	
B	05.07.14	ADD D3270-1 FLAT PATTERN	

RELEASED

04.02.23

D3270-041 FUEL SCUPPER ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36917A01

- NOTES:
- 1) WELD PER DART QSI 004 USING 5356 FILLER ROD.
 - 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
POWDER COAT GLOSS WHITE (REF. 4.3.5.1) PER QSI 005 4.3
 - 3) ALL DIMENSIONS ARE IN INCHES
 - 4) TOLERANCES ARE PER DART QSF 018 UNLESS OTHERWISE NOTED.
 - 5) CONTOUR MAY BE ALTERED TO DOMED SHAPE AT FABRICATOR'S DISCRETION

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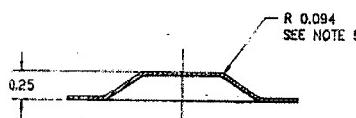
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DART

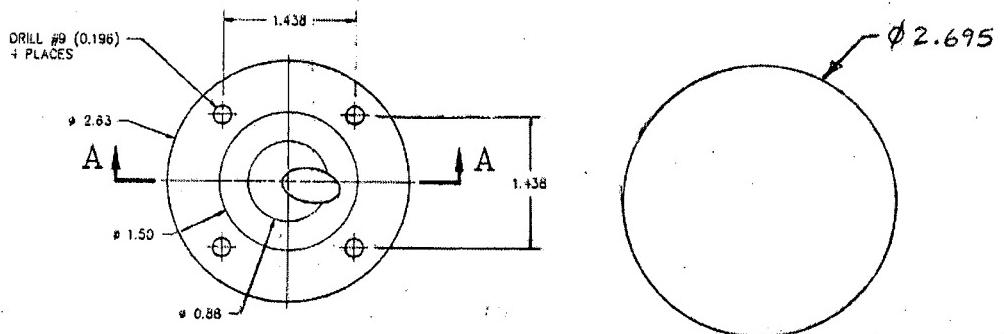
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D3270	SHEET 2 OF 2
DATE	05.07.14	TITLE	SCALE
		FUEL SCUPPER ASSEMBLY	NTS
A	04.02.20	NEW ISSUE	
B	05.07.14	ADD D3270-1 FLAT PATTERN	

RELEASED

04.02.23



SECTION A-A

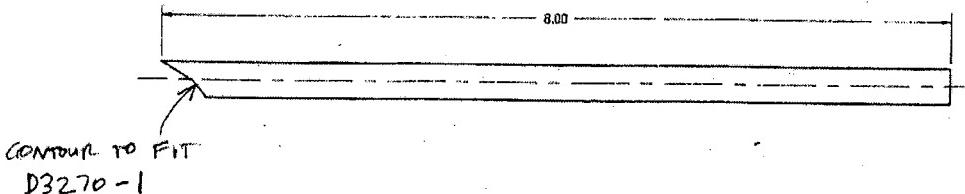


D3270-1 FLAT PATTERN

△ B

D3270-1 MOUNTING BASE

MATERIAL : 6061-T6 ALUMINUM SHEET 0.040" THICK PER QQ-A-250/11 (M6061T6 S.040)



Ø 0.375
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
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WORK ORDER
NO. 36917AO

D3270-3 FUEL OUTLET TUBE

MATERIAL : 6061-T6 ALUMINUM TUBING 0.375" OD X 0.035" WALL (SEAMLESS)
PER MN-T-700/6 OR QQ-A-200/8 OR QQ-A-225/8
(M6061 T6 T 0.375 W:035)